

Date: Friday, 5/25/2007 8:16:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 32581	
Estimate Number : 10009	
P.O. Number : <i>N/A</i>	Part Number : D27351
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2735 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 31235	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/6/2007 Qty: <i>31</i> Um: Each
Checked & Approved By : <i>[Signature] 07.05.28</i>	
Comment : Est Rev:C Removed from 9 Digit 05-10-25 JLM	
est rev D waterjet 06.09.19 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S125	1010-1025 sheet .125
-----	-----------	----------------------



Comment: Qty.: 0.1733 sf(s)/Unit Total : 5.1975 sf(s)
 1010-1025 sheet .125
 batch: *M104699*

SAD 07/06/13

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2735 (D2735-1)
 Dwg Rev: *C*
 Prog Rev: *C*

2-Deburr if necessary

SAD 07/06/13

30 PTO

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/13

30

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/06/18 (X31)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

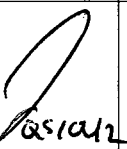

2-Deburr if required: *SAD 07/06/25*

(31) counted

SB 07/07/19 (31)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/13	2.0	^{holes too big} One part was scrap because the jet offset had to be change to 0.016 instead of the regular 0.015 "Hole was too big"	 Pascal	Scrap destroy, replace ϕ is 0.440", acceptable	SLD 07/06/13	En 07/06/13	 Pascal	En 07/06/13

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:16:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 32581

Part Number: D27351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted
EP 07/07/19 (X31)

Comment: INSPECT WORK, TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/08 (31)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(31)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/09

Job Completion



07/08/09

Francis

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

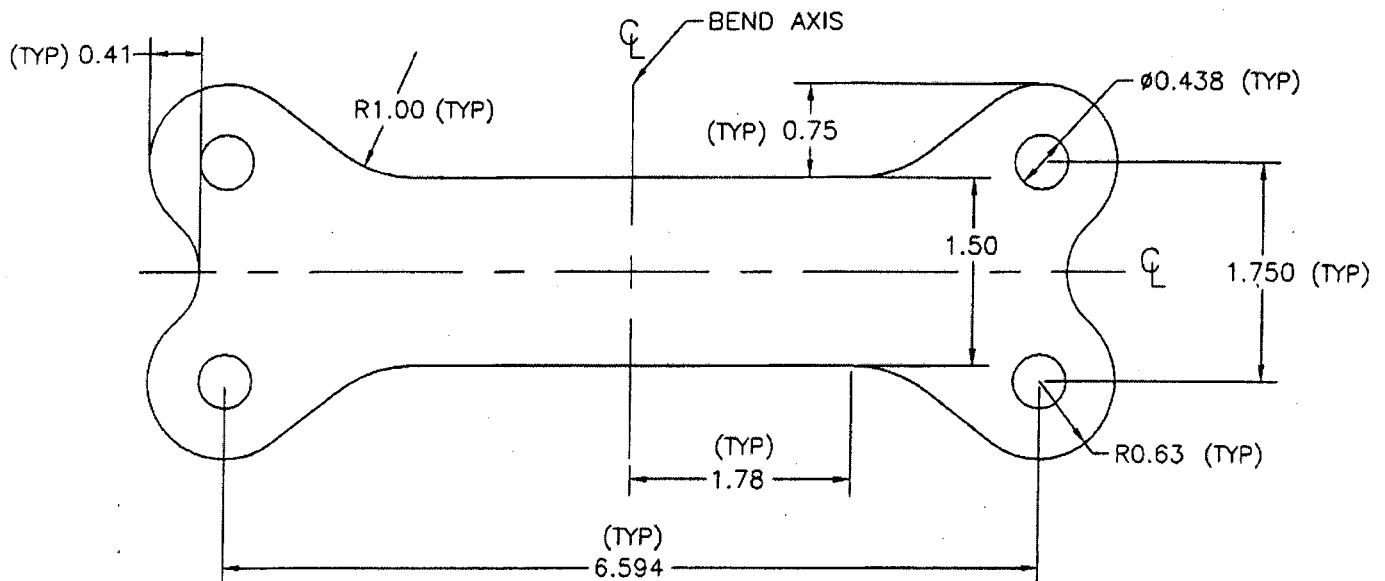
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

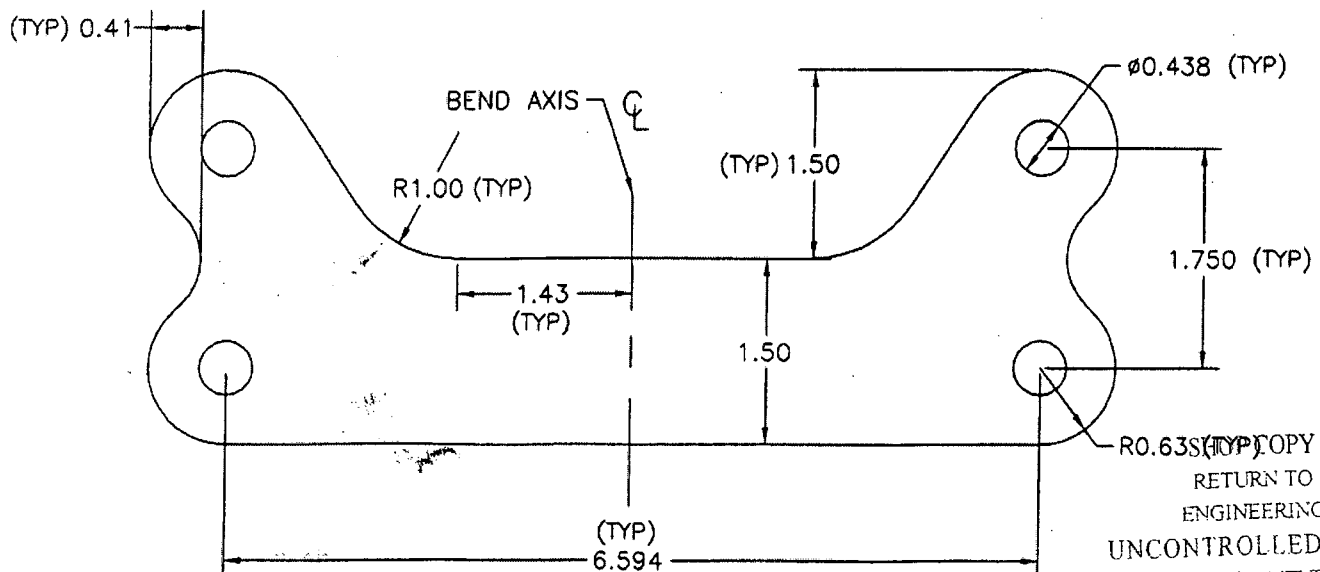


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



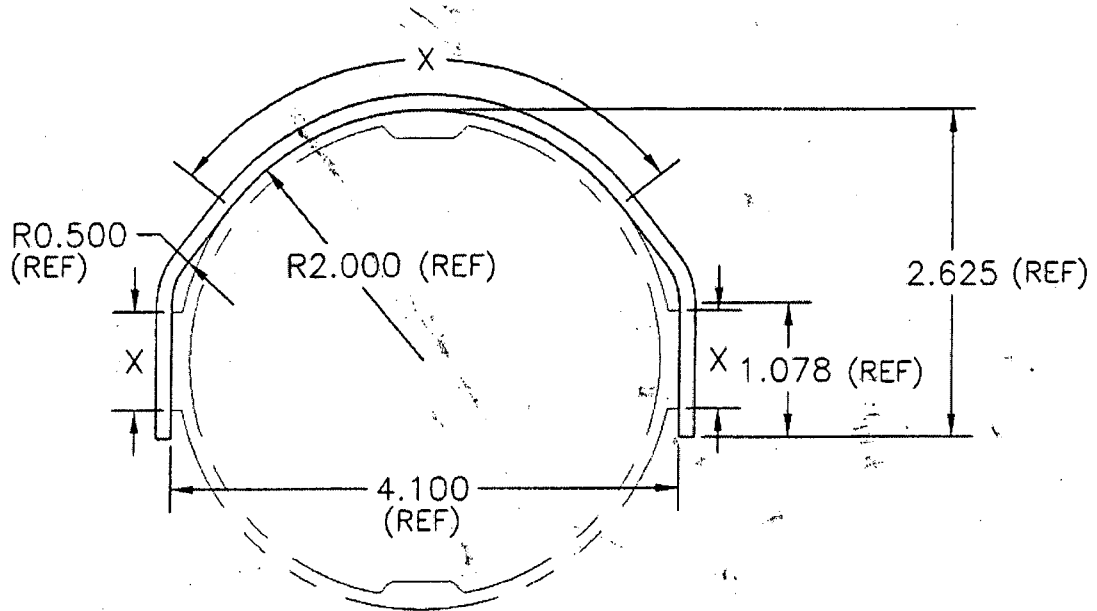
D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (CL)

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32581



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32581